

Work Order ID 62673

Thursday, October 07, 2010 8:08:42 AM



Page 1

Item ID: D3763-1

Accept



Setup Start



Revision ID:

Item Name: End Fitting

Stop



Start Date: 10/6/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10/00-07 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberReject
StampInsp.
Stamp

Draw Nbr	Revision Nbr
D3763	Rev B

100



DOOSAN LATHE

Doosan

Doosan Lathe

Memo

1- Turn as per Folio FA750 Rev: B & Dwg D3763 Rev: B 2-Deburr
per dwg D3763

10/12/16

12 ✓

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

12 ✓

120



QC8- Inspect parts - second check

QC

Quality Control

Memo

0.00

B.A 10/12/17

12 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62673

Page 2

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Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: *WPA*Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

Memo

0.00

u 10.12.17 12

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*10/12/10 JF**u 10.12.17*

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NOTE: Date & initial all entries

Picklist Print

Page 1
1

Thursday, October 07, 2010 8:08:47 AM

Work Order ID: 62673



Parent Item: D3763-1



Parent Item Name: End Fitting

Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-23 new issue DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.000 		Purchased		No		100	f	13.6800	0.125	1.578947 		10/12/16	

ROUND BAR 1.00"

Location	Loc Qty	Loc Code
MAT	11.5	
115609	11.5	
MAT013	2.18	
108876	1.88	
113457	0.3	

11.5 ft

W/O:		WORK ORDER CHANGES							
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	626173
Description: Fitting	Part Number:	D3763-1
Inspection Dwg: D3763 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	<u>S. J.</u>	Audited by:	<u>J. A.</u>	Preliminary Approval:	
Date:	10/12/16	Date:	10/12/17	Date:	

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	
B	10.06.07	Dimensions revised	KJ	 

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY

REVISION A

EX-00000000000000000000000000000000

UNCONTRACTED DRAWING

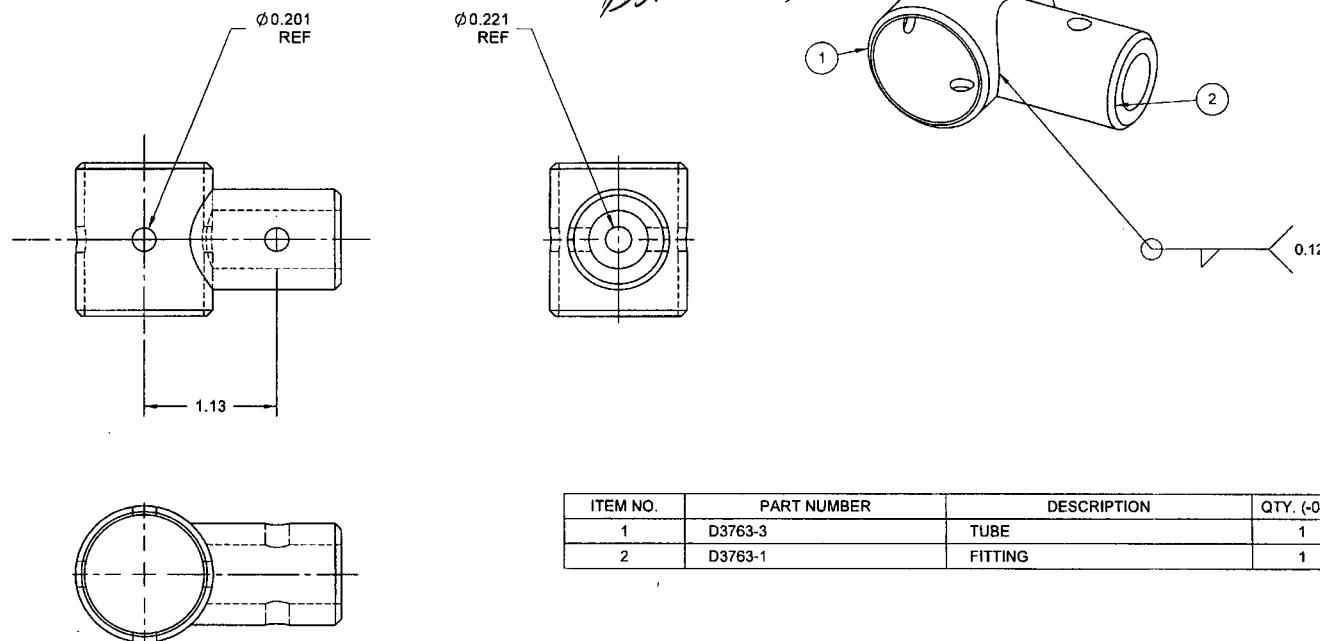
SHEET NO. 1 OF 1

WELDMENT

WORK CENTER

NO. 62473

B10-10-07



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3763-3	TUBE	1
2	D3763-1	FITTING	1

D3763-041 END FITTING ASSYRELEASED
06/07/2010 MPD

B	CHANGE HOLES SIZE, ADD -7 PART AND -045 ASSY	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	N/A	DRAWING NO.	REV. B
MFG. APPR.	N/A	D3763	SHEET 1 OF 9
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	END FITTING	NTS
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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- A NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.03 lbs
 - 8) WELD: PER DART QSI 004

8 7 6 5 4 3 2 1 0

A

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A

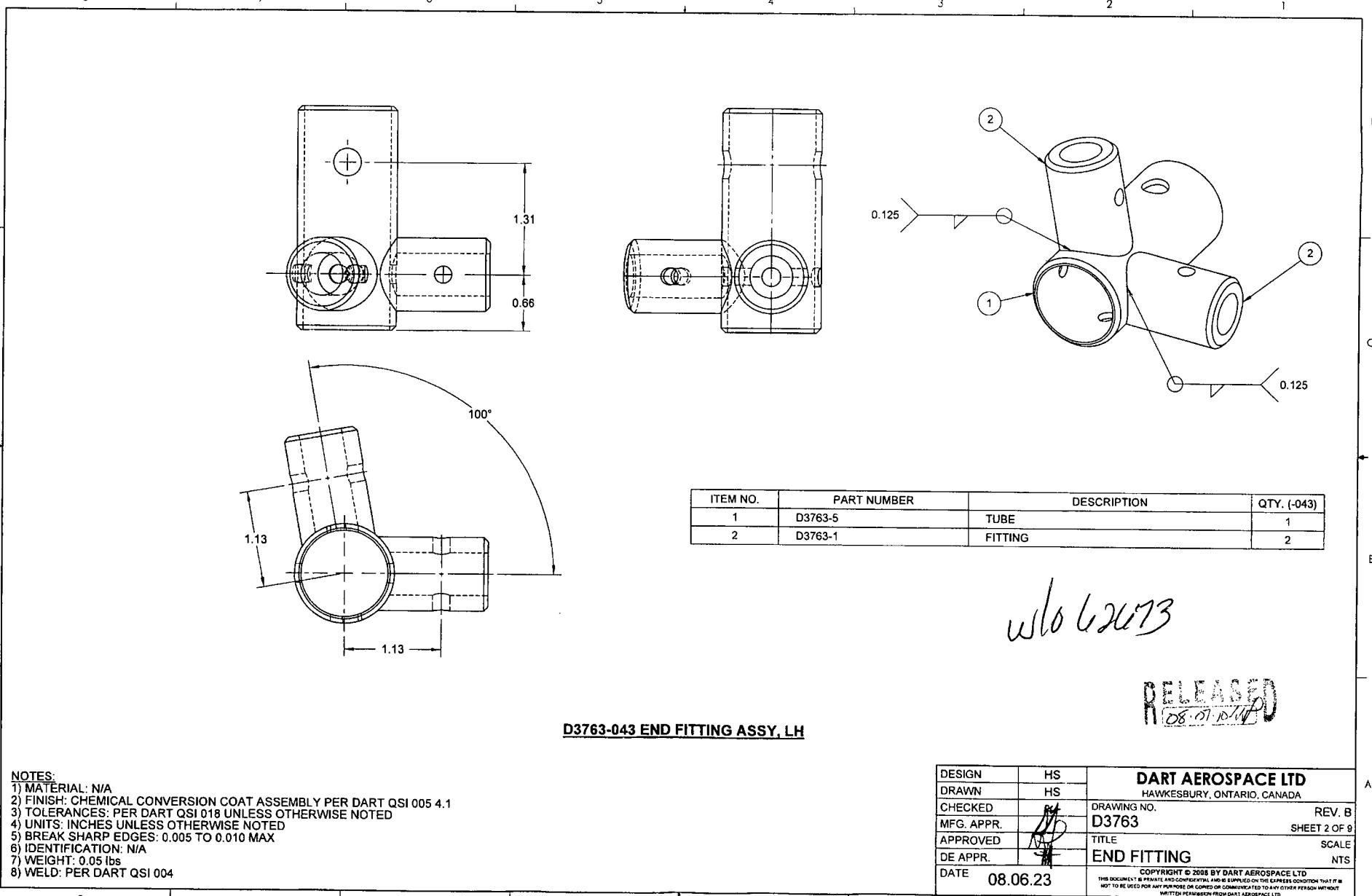
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

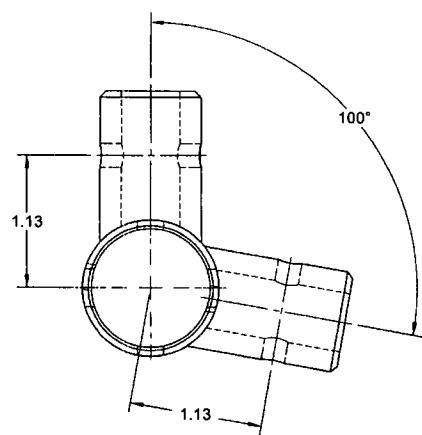
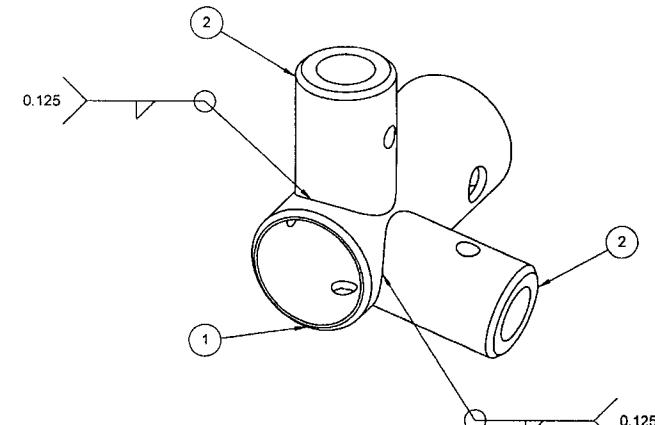
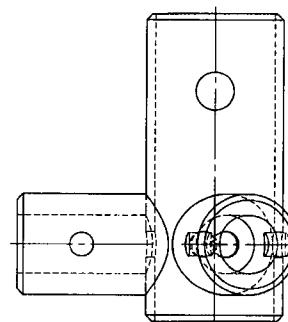
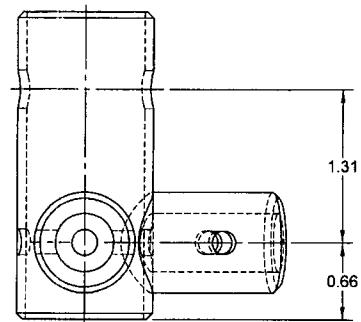
D

C

C

B

B



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-6	TUBE	1
2	D3763-1	FITTING	2

w/o 62623

RELEASED
08-07-10 MTP

D3763-044 END FITTING ASSY, RH

A

A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs
- 8) WELD: PER DART QSI 004

8 7 6 5 4 3 2 1

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RA	DRAWING NO.	
MFG. APPR.	AS	REV. B	
APPROVED	AS	D3763	
DE APPR.	AS	SHEET 3 OF 9	
		TITLE	
		SCALE	
		NTS	
DATE	08.06.23	END FITTING	

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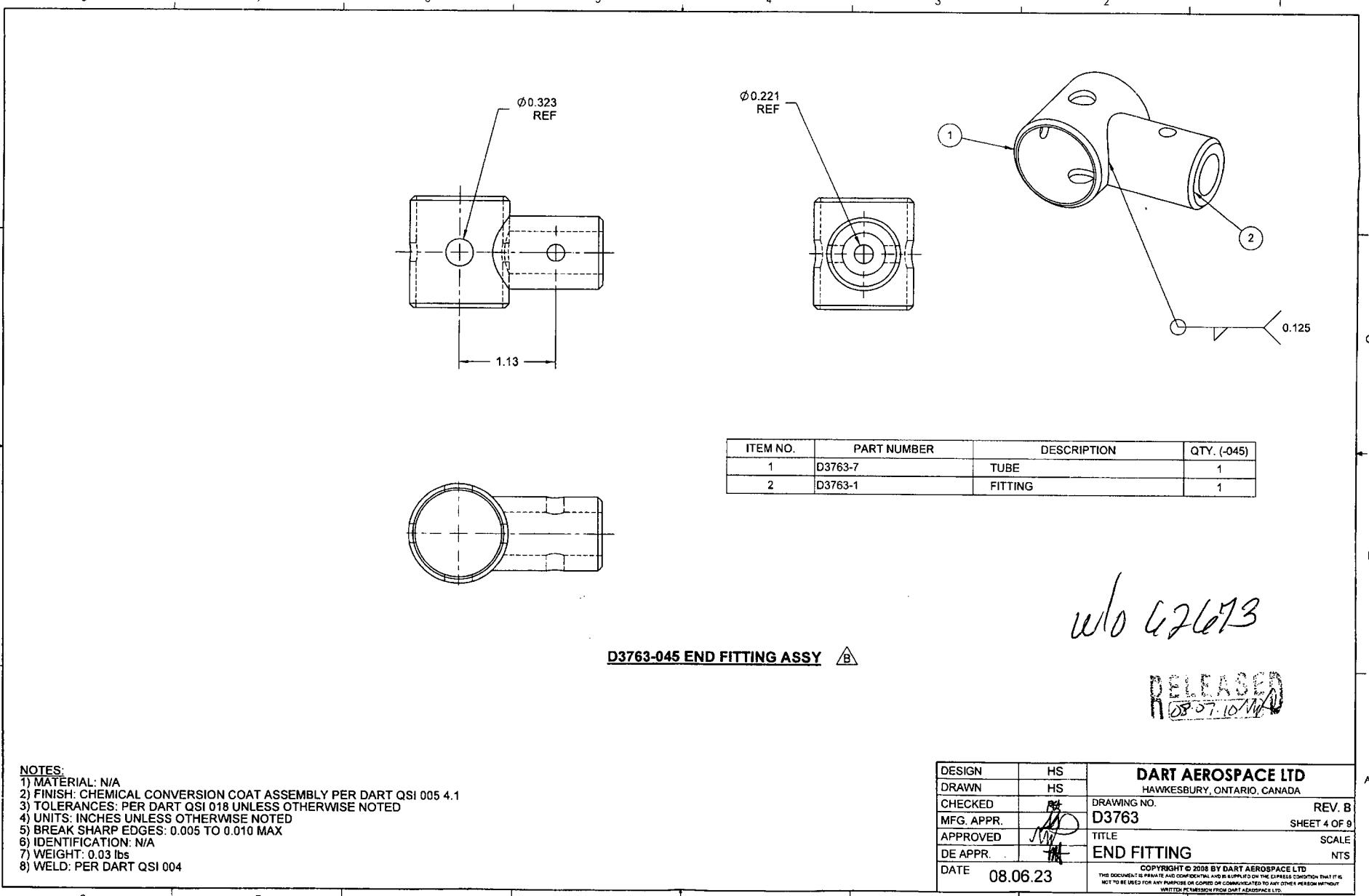
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

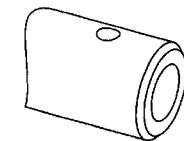
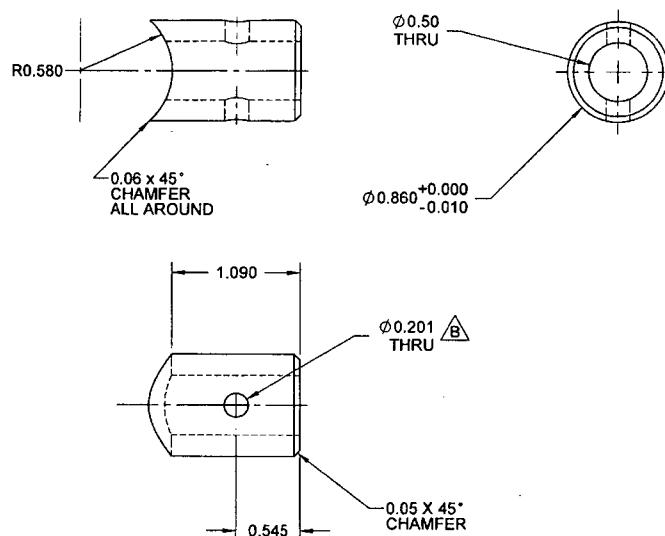
D

C

C

B

B



W0 62673

RELEASED
08-07-10 MHDD3763-1 FITTING

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

8 7 6 5 4 3 2 1

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MJ</i>	DRAWING NO.	
MFG. APPR.	<i>SJ</i>	D3763	REV. B
APPROVED	<i>MW</i>	TITLE	SHEET 5 OF 9
DE APPR.	<i>MW</i>	SCALE	END FITTING
DATE	08.06.23	NTS	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

C

B

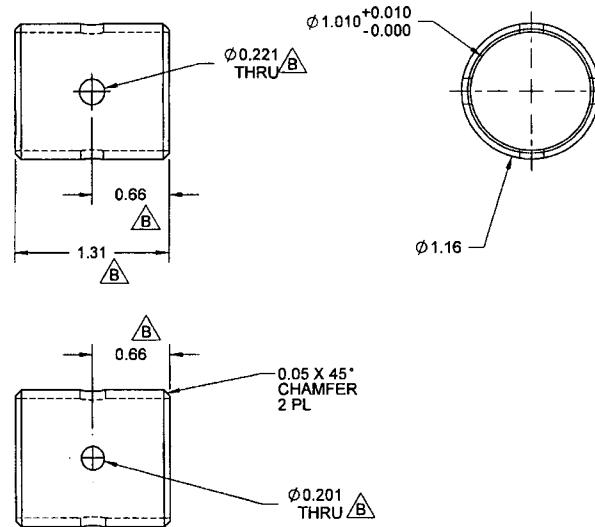
B

A

A

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

**D3763-3 TUBE**

wlo 62673

RELEASER
108-27-10744

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKSLEY, ONTARIO, CANADA	
CHECKED	HS		
MFG. APPR.	<i>[Signature]</i>	REV. B	
APPROVED	<i>[Signature]</i>	D3763	SHEET 6 OF 9
DE APPR.	<i>[Signature]</i>	TITLE	SCALE
DATE	08.06.23	END FITTING	NTS

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8 7 6 5 4 3 2 1

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

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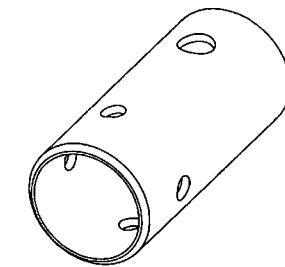
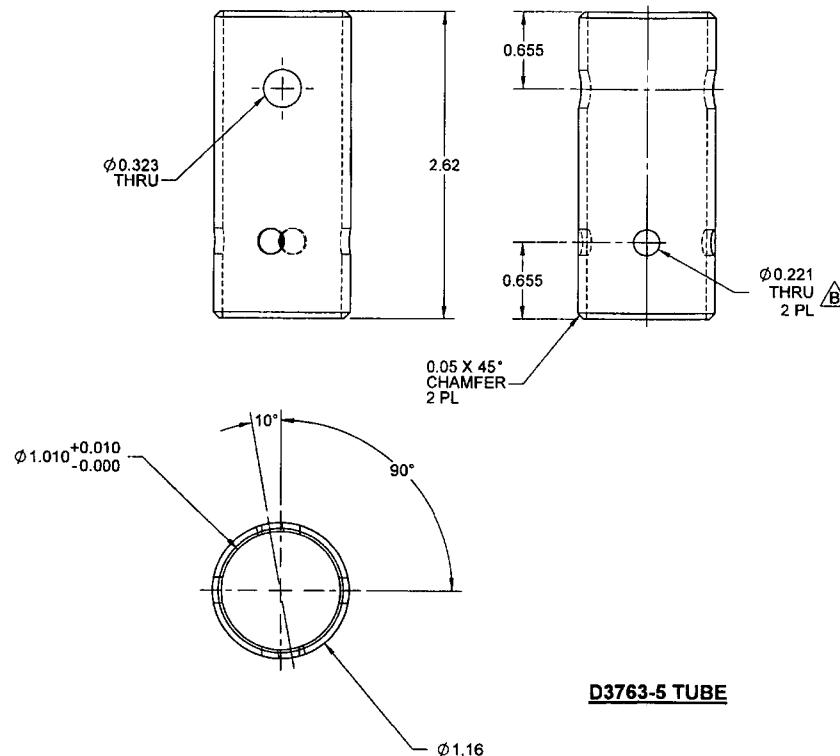
A

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wb 62613
RELEASED
 08-07-10 7:49 AM

DESIGN	HS	DART AEROSPACE LTD
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[initial]</i>	DRAWING NO.
MFG. APPR.	<i>[initial]</i>	REV. B
APPROVED	<i>[initial]</i>	D3763 SHEET 7 OF 9
DE APPR.	<i>[initial]</i>	TITLE END FITTING
DATE	08.06.23	SCALE NTS

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8 7 6 5 4 3 2 1

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

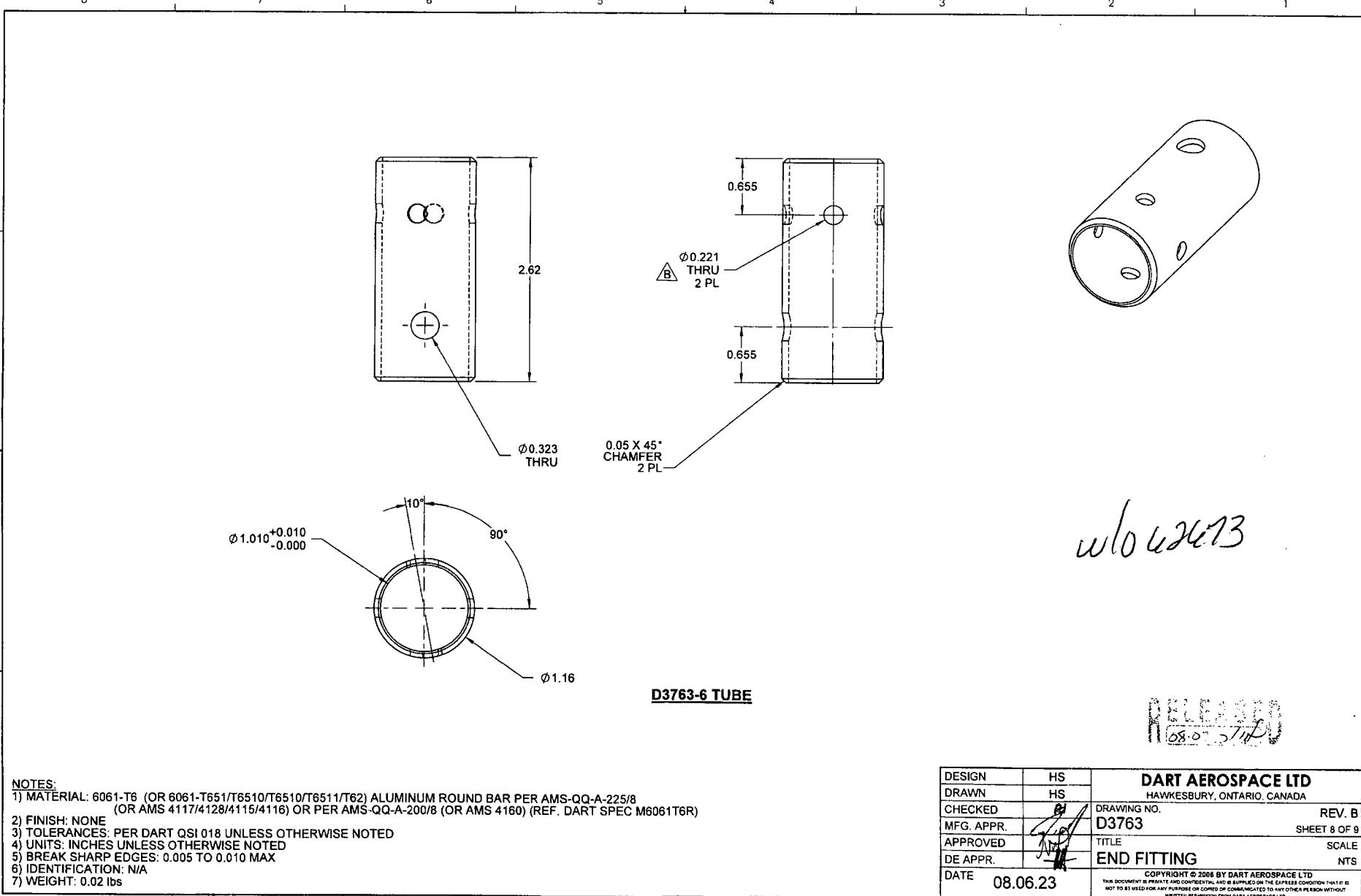
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NOTE: Date & initial all entries



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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

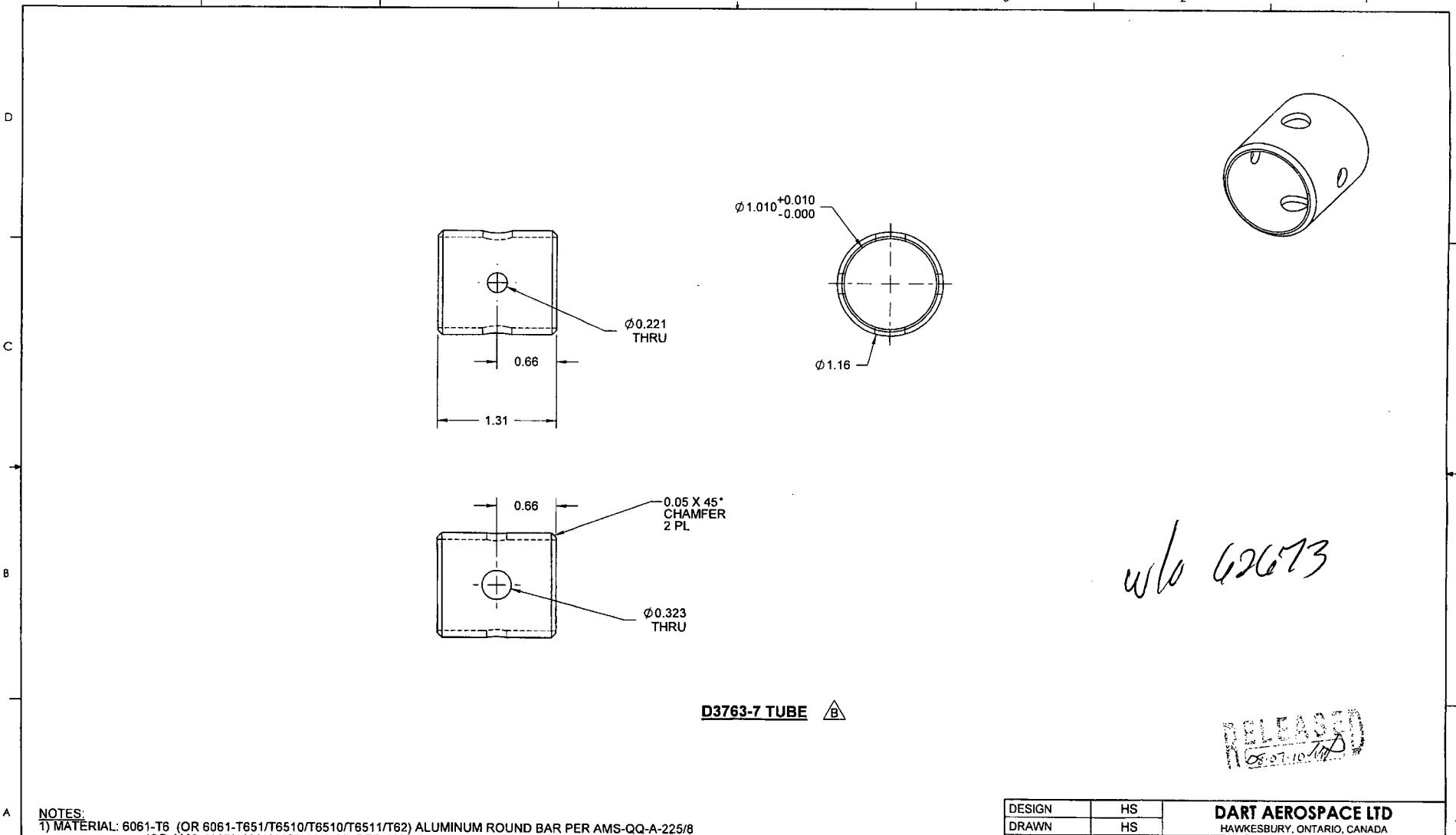
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8 7 6 5 4 3 2 1



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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>✓</i>	DRAWING NO.	
MFG. APPR.	<i>✓</i>	D3763	REV. B
APPROVED	<i>✓</i>	SHEET 9 OF 9	
DE APPR.	<i>✓</i>	TITLE	SCALE
DATE	08.06.23	END FITTING	
NTS			

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